

Work Order ID 50835



Page 1

July 23, 2009 7:38:22 AM

Item ID: D205-634-041

Accept



Setup Start



Revision ID: D

Stop



Item Name: Replacement Skidtube

Start Date: 07/30/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 08/07/2009 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: *mf*

Date: *09-07-23* Tooling:

Date:

Run Start



QC:

Date: SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2580	Rev D								

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy D205-634 bluefile & type labels per PPP D205-634-041 CHG002

on W1051026

N/A

110

0.00



BENDING MACHINE - SKIDTUBES

CNC Bend 1

Memo

0.00

CNC Delta 100 Bender

1-Bend as per program D2580.C on CNC Bender and Folio FT009

2-Cut tubes as per Dwg. D2580

) M 09-7-27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

120

0.00



Skidtubes

Memo

0.00

Skidtubes

1- Deburr ends

2- C'sink holes as per dwg without cutting fluid

3- Prepare tube for welding, remove alodine as required.

4- Scribe batch number insied aft end of tube.

3 BE 09/07/23

130

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

=> S 09/14/23



W/O:		WORK ORDER CHANGES					
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Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

140

0.00



Skidtubes

Memo

0.00

Skidtubes

1-Weld step D2576 as per Dwg. D2580 and QSI 004

A/R□□□ Aluminum Rod

mill 679

2-Prep per QSI 005 and weld crossbolt spacers D2579 as per Dwg. D2580, QSI 004.

For D2579 spacers, weld one side, pass 3/8" drill, weld other side, pass 3/8" drill

A/R□□□ Aluminum Rod

mill 679

BE 09/07/23

3-Grind welds as per Dwg D2580 Grind flush ridge made from bending

4-Drill holes for wearplates using DT 8217 & DT8937 Open holes to 19/64", adjust stopper not to hit web. Debur

5-Counterbore crossbolt spacers to 7/16" ID x 1.0" deep as per Dwg D2580. Debur holes

6-Drill pilot holes for aft cap using DT 8215 Open holes to 0.208". Debur

7-Drill pilot holes for Tow ring using DT8091, open to .640" and Debur

BE 09/07/30

W/O:		WORK ORDER CHANGES					
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Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Stop



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

QC10- Inspect visual per QSI004- ground welds

0.00



QC

Memo

0.00

2) S 07107131

40

p

Quality Control

160

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

2) S 07107131

40

p

Quality Control

170

Pressure Wash per QSI005 4.3

0.00



HandFinish

Memo

0.00

BK 070807 - D.

Hand Finishing

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Item Name:	Replacement Skidtube					
Start Date:	07/30/2009	Start Qty:	1.00			
Required Date:	08/07/2009	Req'd Qty:	1.00			
Reference:						
				Cust Item ID:		
				Customer:		

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180 	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
Powdercoat	Memo	0.00							
Powder Coating	START TIME: 11:50 AM OVEN TEMPERATURE: 320°C FINISH TIME: 12:20 PM								
190 	QC3- Inspect Part Finish	0.00							
QC	Memo	0.00							
Quality Control									

MI1248 09-08-04

(X)

2

Br 09-08-5

(1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

200

0.00



HandFinish

Memo

0.00

Hand Finishing

1-Install inserts & wearplates & Gaskets as per Dwg. D2580. Use a drop of Sikaflex on insert holes before installing wearplates
A/R ☐ ☐ ☐ Sikaflex-291 ☐ M111557
Sikaflex expire date: 10/01

2-Coat D2594-3 O' rings with Petroleum Jelly and install on D2594-1 plugs as per Dwg D2580

3-Inspect for foreign object per QSI 024

4-Install 2855 Aft Cap as per Dwg D2580 and seal Fwd Step & Aft Cap with Sikaflex. Clean excess adhesive
A/R ☐ ☐ ☐ Sikaflex-291 ☐ M111557
Sikaflex expire date: 10/01

5-Wing Walk as per Dwg D2580 and QSI 005 4.4
Batch: M112106

UMP 09/08/05

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID: 50835

Parent Item: D205-634-041RevD

Parent Item Name: Replacement Skidtube

Comments:

Start Date: 07/30/2009

Required Date: 08/07/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2580-1RevD		Manufactured	No			110	Each	1.0000	1.0000			
205 Skidtube bent detail												

Warehouse

Work Order ID 50835

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Item ID: D205-634-041

Accept

Setup Start

Revision ID: D

Stop

Item Name: Replacement Skidtube

Start Date: 07/30/2009 Start Qty: 1.00

Cust Item ID:

Required Date: 08/07/2009 Req'd Qty: 1.00

Customer:

Reference:

Run Start

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
210	QC5- Inspect part completeness to step on W/O	0.00							
QC	Memo	0.00							
Quality Control	Inspect Aft Cap, Fwd Step and Wing Walk of work to Current Step Inspect for Foreign objects per QSI 024								
220	Packaging	0.00							
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPPD205-634-041								
	Location:								
	PPP Rev:								
230	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

MF 09-08-08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

W/O:		WORK ORDER CHANGES					
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Page 2 **A**

Work Order ID: 50835

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Parent Item Name: Replacement Skidtube

Comments:

Start Date: 07/30/2009

Required Date: 08/07/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2855RevA		Manufactured	No			200	Each	15.0000	1.0000			

Cap

Warehouse	Loc Qty	Loc Code
<u>Location</u>		
Main Warehouse	30513	
ST	15	
10360	2	
35663	7	
41340	1	
42343	3	
42806	2	

x1

UMD 09/08/05

AN3-5A

Purchased

No

200

Each

2,562.000 2.0000



Bolt

Warehouse	Loc Qty	Loc Code
<u>Location</u>		
Main Warehouse		
ST	2562	
100188	246	
105057	2246	
15205	70	

x2

UMD 09/08/05

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID: 50835

Parent Item: D205-634-041RevD

Parent Item Name: Replacement Skidtube

Comments:

Start Date: 07/30/2009

Required Date: 08/07/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN960JD10L		Purchased	No			200	Each	7,073.000	2.0000			



Washer

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST 7157

101291 16

104885 153

105793 236

109632 1752

110985 5000

Main Warehouse

ST182 -84

109632 -84

ALS7-1032-130

Purchased

No

200

Each

3,850.000 50.0000



Insert

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST 3850

108606 52

111529 1798

111779 2000

110511

X2 UMD 09/08/05

X50 UMD 09/08/05

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Shop Packet Print

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Comments:

Start Date: 07/30/2009

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Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN3C4A 		Purchased	No			200	Each	152.0000	50.0000			
BOLT												

Warehouse Location
Main Warehouse
ST
112082

Loc Qty
112314
152
152

Loc Code

X50 UMD 09/08/05

AN960C10L



washer

Purchased

No

200

Each

4,758.000

50.0000

Warehouse Location
Main Warehouse
ST
103585
112116

Loc Qty
4758
100
4658

Loc Code

X50 UMD 09/08/05

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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D3566-13RevC		Manufactured	No			200	Each	32.0000	1.0000			
												
Gasket												

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
FP17	-1	
46889	-1	
Main Warehouse		
ST	33	
45717	1	
46889	6	
47435	8	
48166	18	

X1 UMD 09/08/05

D3566-5RevC		Manufactured	No			200	Each	23.0000	1.0000			
												
Gasket												

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	23	
36113	1	
46186	1	
47318	1	
48167	20	

X1 UMD 09/08/05

W/O:		WORK ORDER CHANGES					
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D3566-1RevC		Manufactured	No			200	Each	24.0000	2.0000			
Gasket												

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

46349

47434

48165

48557

24

1

2

10

11

200

Each

21.0000

1.0000

D3564-11RevD

Manufactured

No

Wearshoe

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

45823

47432

48553

21

1

8

12

X2

UMP 09/08/05

X1

UMP 09/08/05

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D3564-13RevD		Manufactured	No			200	Each	34.0000	1.0000			
Wearshoe												

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

FP17

13

48554

13

Main Warehouse

ST

21

45409

3

46495

10

47867

8

200

Each

18.0000

1.0000

XI UMP 09/08/05

D3564-9RevD

Manufactured

No

Wearshoe

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

18

44659

1

45825

1

47316

4

48556

12

Y UMD 09/08/05

July 23, 2009 7:38:21 AM

Shop Packet Print

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Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3564-5RevD  Wearshoe		Manufactured	No			200	Each	23.0000	1.0000			

Warehouse

Loc Qty

Loc Code

Location

OFFSHORE

FG

2

34806

2

Main Warehouse

FP19

12

48555

12

Main Warehouse

ST

9

45824

1

47433

1

48164

7

D2594-3RevC

Manufactured No

200

Each

918.0000

16.0000



O-Ring, 205 Skidtube

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

918

27168

44

29908

874

X1 UMD 09/08/05

X16 UMD 09/08/05

July 23, 2009 7:38:21 AM

Shop Packet Print

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 50835

Parent Item: D205-634-041RevD

Parent Item Name: Replacement Skidtube


Comments:

Start Date: 07/30/2009

Required Date: 08/07/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2594-1RevC  Plug, 205 Skidtube		Manufactured	No			200	Each	716.0000	16.0000			

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

716

42221

16

42807

92

43884

103

46435

3

47251

502

X16

ump 09/08/05

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NOTE: Date & initial all entries

DART

DESIGN <i>[Signature]</i>	DRAWN BY <i>RH</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2580	REV. D SHEET 1 OF 3
DATE 07.02.27		TITLE 205 SKIDTUBE ASSEMBLY	SCALE NTS
A	96.09.16	NEW ISSUE	
B	96.12.02	AS MANUFACTURED	
C	98.08.26	REDRAWN, INCLUDED DEO 9094/9097	
D	07.02.27	CHANGE TO SS WEARPLATES AND GASKETS, INCLUDE DEO 9124/9183	

538054
RELEASED
07.06.28 *[Signature]*

QTY -041	QTY -045	Part Number	Description
X		D2580-041	SKIDTUBE ASSEMBLY
	X	D2580-045	SKIDTUBE ASSEMBLY
1	1	D2500-1-190	EXTRUSION
1	1	D2576-3	STEP
20	24	D2579	CROSS BOLT SPACER
16	16	D2594-1	PLUG
16	16	D2594-3	O-RING
1	1	D2596	205 WEB
1	1	D2855	AFT CAP
1	1	D3564-5	WEARSHOE
1	1	D3564-9	WEARSHOE
1	1	D3564-11	WEARSHOE
1	1	D3564-13	WEARSHOE
2	2	D3566-1	GASKET
1	1	D3566-5	GASKET
1	1	D3566-13	GASKET
50	50	ALS7-1032-130 or AKS7-1032-130 or AKS4-1032-130 or AELS-1032-130	INSERT
50	50	AN3C4A	BOLT
2	2	AN3-5A	BOLT
50	50	AN960C10L	WASHER
2	2	AN960JD10L	WASHER

GENERAL NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) ALL DIMENSIONS ARE IN INCHES
- 3) INSERT D2596 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241 ADHESIVE PER DART QSI 015 BEFORE BENDING. ENSURE HOLES LINE-UP.
- 4) BEND AS A SMOOTH RADIUS STARTING WITH A MAXIMUM CENTERLINE RADIUS OF 60 AND ENDING WITH A MINIMUM RADIUS OF 30. A MAXIMUM REDUCTION OF 0.200 IN DIAMETER IS ALLOWABLE IN THE BENT PORTION OF THE TUBE.
- 5) USE DART DRILL TEMPLATE TD2577-205 TO LOCATE AND DRILL Ø0.297 HOLES FOR WEARSHOE INSERTS. INSTALL ALS7-1032-130 PER SECTION D-D (50 PLACES) AFTER FINISH. INSTALL AN3C4A BOLTS AND AN960C10L WASHERS WITH SIKAFLEX-241/-291.
- 6) WELDING TO BE DONE PER DART QSI 004.
- 7) FINISH:
SEE NOTES ON
PAGE 2 FOR D2580-041 AND
PAGE 3 FOR D2580-045
- 8) INSERT D2594-1 PLUG C/W D2594-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE) AFTER FINISH (16 PLACES).

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RELEASED
07-06-28

Diagram illustrating the underside of the component, showing the location of the GRIND FLUSH (4 PLACES) and the D2576-3 STEP. The diagram also indicates the LOCATION RIDGE ON UNDERSIDE OF D2576.

Technical drawing of a circular component with a central hole. The drawing includes the following labels and dimensions:

- DRILL PRIOR TO D2855 CAP INSTALLATION (2 PLACES)**: Points to two locations on the outer rim of the component.
- SEAL WITH SIKAFLEX-241/-291**: Points to the gap between the component and the central cap.
- AN3-SA BOLT (1)**: Points to a bolt passing through the central hole.
- AN960JD10L WASHER (1)**: Points to a washer on the bolt.
- (2 PLACES)**: Points to two locations on the inner rim of the central hole.
- D2855 CAP**: Points to the central cap being installed.
- 0.208**: Dimension indicating the diameter of the central hole.
- 0.40**: Dimension indicating the thickness of the component.

D2579 SPACER

D2596 WEB (REF)

ALS7-1032-130 (REF)
(TYP 50 PLACES)

5

AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR Ø0.508 HOLES ONLY:

1. CHAMFER H/D 0.050 X 45°
2. INSERT D2579 SPACER (20 PLACES)
3. WELD INTO PLACE AND GRIND FLUSH
4. C-BORE D2579 SPACER TO Ø0.437 X 1.00 DEEP

i) FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1 PRIOR TO INSERTING D2596 WEB
POWDER COAT ASSEMBLY GLOSS WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4

37.50
DISTANCE TO AFT END
OF D2596 WEB
3
7
1.750
1.750
ø0.508 (TYP.)
(40 PLACES)
REFER TO DETAIL A
8.750
17.375
26.000
34.188
57.313 (REF)
7 EQUAL SPACES
8.188 PITCH
38.0
91.500
190.0
(D2500-1)

0.5

1.5

1.5

0

P P P P P P P P

REFER TO DETAIL C

BLACK ANTI-SKID TO 0.5 ABOVE LOCATION RIDGE

BLACK ANTI-SKID TOP OF STEP TO 0.5 ABOVE BOTTOM EDGE

WELD AS PER DETAIL B

D3566-1

D3566-5

D3566-1

D3566-13

D3564-11

D3564-5

D3564-9

D3564-13





AN3C4A BOLT (1)

AN960C10L WASHER (1)

(50 PLACES)

W/O
50635

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DESIGN		DRAWN BY	
CHECKED		APPROVED	
DATE			
07.02.27			

DART DART AEROSPACE LTD.
HAWKESBURY, ONTARIO, CANADA

DRAWING NO.		REV. D
D2580		SHEET 2 OF 3
TITLE		SCALE
205 SKIDTUBE ASSEMBLY		1:24

W/O:		WORK ORDER CHANGES					
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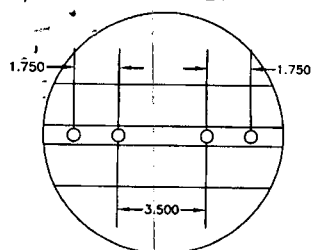
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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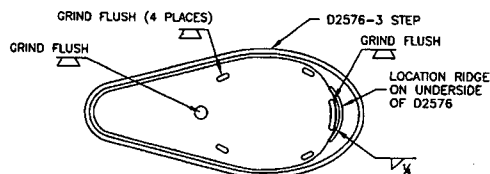
NOTE: Date & initial all entries

DETAIL E
SCALE 5:24

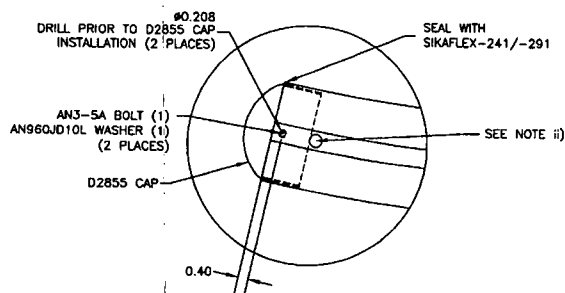


RELEASED
07.02.27

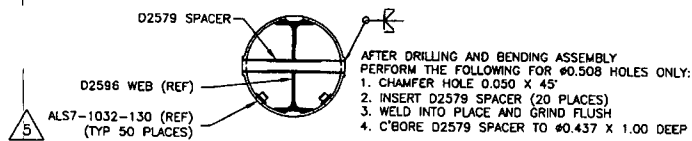
DETAIL F
SCALE 5:24



DETAIL G
SCALE 5:24



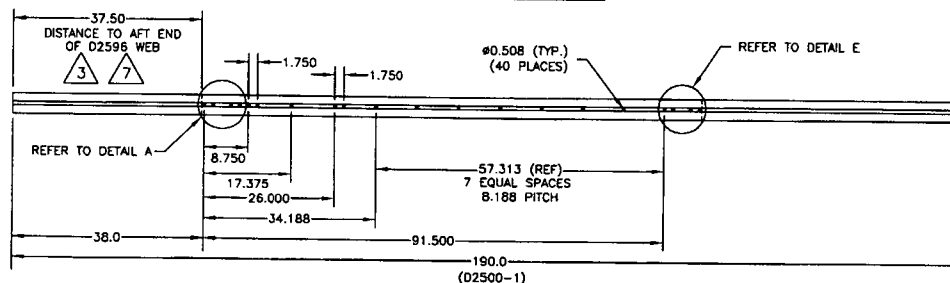
SECTION H-H
SCALE 5:24



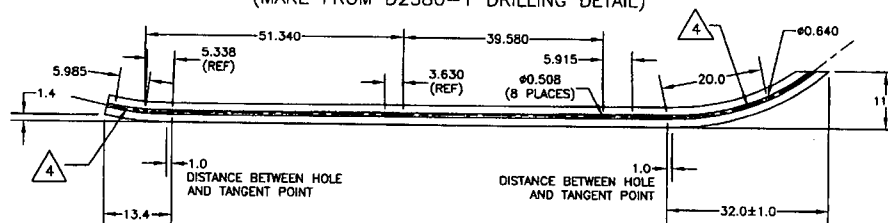
D2580-045 NOTES

- FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1 PRIOR TO INSERTING D2596 WEB POWDER COAT ENTIRE ASSEMBLY GREEN (REF. 4.3.5.8) PER DART QSI 005 4.3 BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4
- IT IS ACCEPTABLE TO GRIND A RELIEF IN THE D2855 AFT CAP TO PREVENT INTERFERENCE WITH THE SPACER AT THIS LOCATION

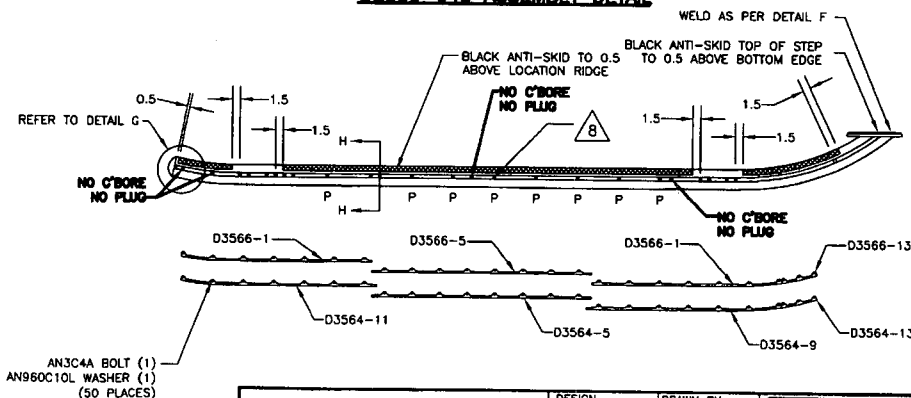
D2580-1 DRILLING DETAIL



D2580-5 BENDING AND CUTTING DETAIL
(MAKE FROM D2580-1 DRILLING DETAIL)



D2580-045 ASSEMBLY DETAIL



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DESIGN <i>RH</i>	DRAWN BY <i>RH</i>	DART	DART AEROSPACE LTD. WARRICKSURY, OXFORD, CANADA
CHECKED <i>H</i>	APPROVED <i>H</i>	DRAWING NO. D2580	REV. D SHEET 3 OF 3
DATE 07.02.27	TITLE 205 SKIDTUBE ASSEMBLY	SCALE 1:24	

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

NO. 205

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: Barday Elliott
Job number: D205 634 041 50835
Part number: D205 634 041
Description: 205 skid tube
Welding Process: Tig[☒] Mig[]
Base material: Aluminium
Current: AC[☒] DC[]

TEST REQUIREMENTS AND RESULTS

Visual: pass[☒] fail[]
Penetration: pass[☒] fail[]

UNACCEPTABLE

Cracks: pass[☒] fail[]
Undercut: pass[☒] fail[]
Pin holes: pass[☒] fail[]
Overlap (cold lap): pass[☒] fail[]
Porosity (surface): pass[☒] fail[]
Coloration: pass[☒] fail[]

REFERENCE ONLY

Qualifier P.C. [Signature] Date of Test Coupon 09-07-30

Welder Barday Elliott Date of Test Coupon 09/07/30

The above named individual is qualified in accordance with AWS D17.1.2001 to weld